

# Work Order ID 96348

January-24-13 1:17:47 PM

**\*96348\***

Page 1

Item ID: D2893-1

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 2.75 Support

Start Date: 1/24/13 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 2/07/13 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 13-01-24 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2893	C
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100		0.00							
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**\*100\*** HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

1-Machine as per Folio FA081  
2-Deburr

0.00

FK 13/01/29  
PO 13/01/31

20

110		0.00							
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**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

FK 13/01/29  
PO 13/01/31

20

120		0.00							
-----	--	------	--	--	--	--	--	--	--

**\*120\***

QC8- Inspect parts - second check

QC

Memo

Quality Control

0.00

13/02/03

20

DAS  
14  
2-89

**\*96348\***

Page 2

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**\*20\***

\*20\*

Run Start \*NR1\*

Stop \*NR2\*

Date:

## Insp. Stamp

3-2-3

## Packaging

 $x$ 

20

7

AS  
13-2-5

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**\*96348\***

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Item ID: D2893-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 2.75 Support

Start Date: 1/24/13 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 2/07/13 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

13/2/6 JH

pl 13-025

# Picklist Print

January-24-13 1:17:50 PM

Page 1

Work Order ID: 96348

\*96348\*

Parent Item: D2893-1

\*D2893-1\*

Parent Item Name: 2.75 Support

Start Date: 1/24/13

Required Date: 2/07/13

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	2.0000	0.5	10.52632			

\*DSK078\*

D2893-1 TURNING DETAIL

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Location

Loc Qty

Loc Code

MAT060

2

.93804

2

95996

10

FK 13/01/29.

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 96348
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b> D2893-1
<b>Inspection Dwg: D2893</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.995	2.995	2.995	2.995	2.994
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.142	.142	.142	.142	.143
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.143	.139	.139	.141
AG	0.140	0.160		.147	.148	.147	.147	.147
AH	1.360	1.400		1.377	1.375	1.376	1.374	1.375
AI	0.040	0.060		.049	.047	.050	.047	.048
AJ	1.190	1.230		1.217	1.215	1.213	1.214	1.217
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.532	2.533	2.533	2.533
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> FK	<b>Date:</b> 13/01/29
<b>Audited by:</b> DAS 14 9-89	<b>Date:</b> 13/02/03
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	96348
<b>Description: Ø2.750 Support</b>		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg: D2893</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	2.985	3.005		2.997	2.997	2.997	2.997	2.997
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.142	.141	.141	.141	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.142	.142	.141	.141	.141
AG	0.140	0.160		.149	.149	.147	.148	.149
AH	1.360	1.400		1.378	1.375	1.375	1.375	1.377
AI	0.040	0.060		.048	.047	.049	.055	.055
AJ	1.190	1.230		1.218	1.215	1.217	1.215	1.217
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.533	2.529	2.529	2.532	2.532
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b>	F.R.	<b>Date:</b>	13/01/30
<b>Audited by:</b>	DAS 14 9-89	<b>Date:</b>	13/02/03
<b>Preliminary Approval:</b>		<b>Date:</b>	

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<b>Description: Ø2.750 Support</b>		<b>Part Number:</b>	D2893-1
<b>Inspection Dwg: D2893</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11	12	13	14	15
HAAS Section								
AA	2.985	3.005		2.991	2.993	3.000	3.001	2.998
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.126	.125	.129	.128	.128
AD	0.040	0.060		.049	.049	.049	.049	.049
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.139	.140	.137	.137
AG	0.140	0.160		.150	.151	.150	.150	.150
AH	1.360	1.400		1.374	1.373	1.375	1.378	1.373
AI	0.040	0.060		.050	.047	.045	.044	.046
AJ	1.190	1.230		1.202	1.211	1.214	1.217	1.213
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.532	2.535	2.535
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	✓	✓	✓	✓

<b>Measured by:</b> PD	<b>Date:</b> 13/01/13
<b>Audited by:</b> DAU 14 8-8	<b>Date:</b> 13/02/03
<b>Preliminary Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
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<b>Inspection Dwg: D2893</b>		<b>Rev: C</b>	<b>Page 1 of 1</b>

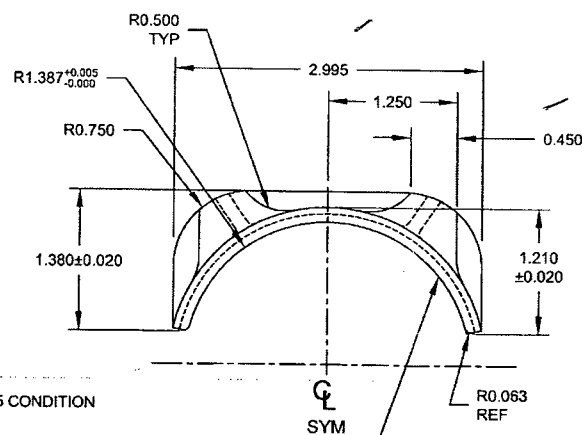
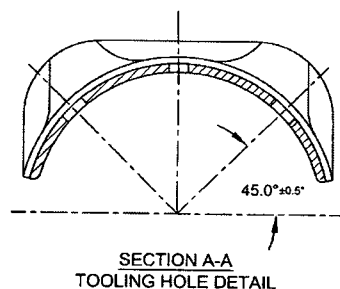
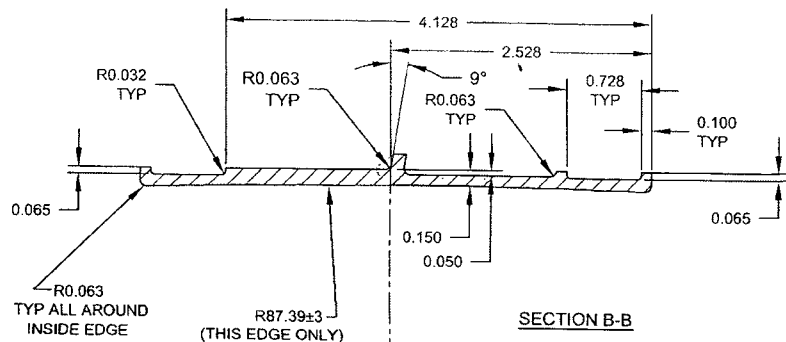
### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	2.985	3.005		2.998	2.998	2.998	3.001	2.999
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.145	.145	.145	.140	.140
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.188	.188	.188	.188	.188
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.151	.152	.150	.151	.148
AH	1.360	1.400		1.380	1.380	1.380	1.382	1.382
AI	0.040	0.060		.050	.049	.049	.048	.047
AJ	1.190	1.230		1.220	1.218	1.220	1.222	1.222
AK	0.010	0.020		.010	.010	.010	.010	.010
AL	0.053	0.073		.060	.060	.060	.060	.060
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject				✓	—	—	—	—

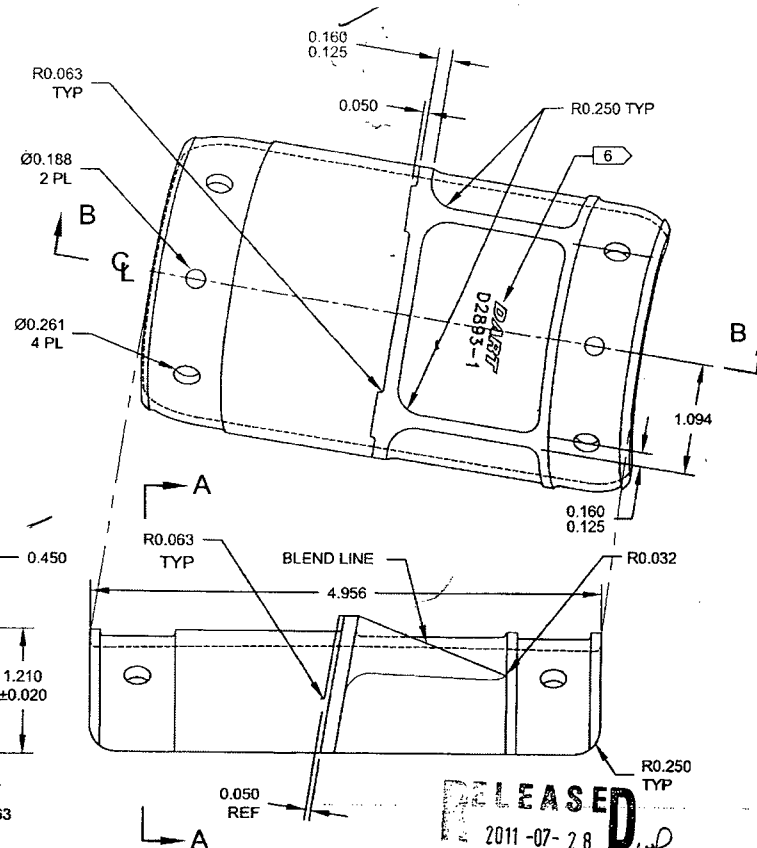
<b>Measured by:</b>	86	<b>Date:</b>	13.02.01
<b>Audited by:</b>	DAS 94 9-89	<b>Date:</b>	13/02/03
<b>Preliminary Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	








D2893-1 SUPPORT



**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRC)  
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2893	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NT
DATE	11.07.15	COPYRIGHT © 2001 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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SERIES

WFO

WFO

NO - 96348 MJS

13-01-24